

# Work Order ID 66591

Tuesday, February 22, 2011 1:14:50 PM

Page 1

Item ID: D3520-3

Accept

Setup Start

Revision ID:

Stop

Item Name: Spacer

Start Date: 2/22/2011 Start Qty: 12.00

Cust Item ID:

Required Date: 2/25/2011 Req'd Qty: 12.00

Customer:

Reference:

Approvals:

Process Plan: *MF*

Date: *11-02-20*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3520

B

100

0.00



Doosan

Doosan Lathe

DOOSAN LATHE

Memo

0.00

1-Turn as per Dwg. & Folio FB038

DWG REV: *12*

FOLIO REV: *N/A*

2-Deburr

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Quality Control

Memo

0.00

*11/3/1*

*12*

*12*

*12*

*12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Revision ID:

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Start Date: 2/22/2011 Start Qty: 12.00

Required Date: 2/25/2011 Req'd Qty: 12.00

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Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

150

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

160

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

320 OF

OVEN TEMPERATURE:

FINISH TIME:

2:10

12 x

12x m-f 11/03/02

12x m-f 11/03/02

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

12 4 21 11/03/03

180

HandFinishing

0.00



HandFinish

Memo

0.00

Hand Finishing

Install Inserts as per Dwg D3488

11-03-03

190

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11-03-03

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

200

Identify as per dwg & Stock Location: 64

0.00



Packaging

Memo

0.00

Packaging

210

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/4 sf 120

11/03/04 JF  
me  
11-03-04

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, February 22, 2011 1:14:47 PM

Page 1

Work Order ID: 66591



Parent Item: D3520-3



Parent Item Name: Spacer

Start Date: 2/22/2011

Required Date: 2/25/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 11-02-22 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6R1.000

Purchased

No

100

f

27.6140

0.03

0.378947



11/3/11

ROUND BAR 1.00"

## Location

## Loc Qty

## Loc Code

MAT

25.434

115609

1.434

116406

24

MAT013

2.18

108876

1.88

113457

0.3

4.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

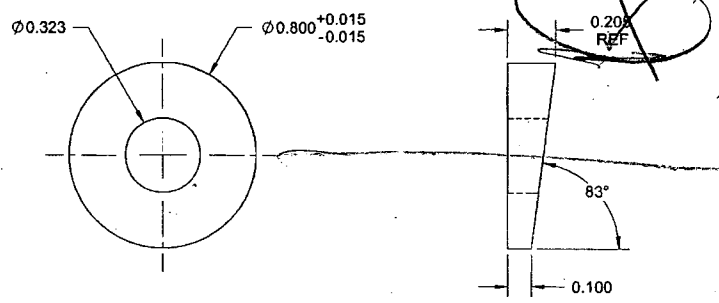
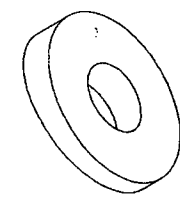
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



0000411



#66591

**D3520-3 SPACER**

**RELEASED**  
2011-02-10  
JM

**NOTES:**

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM ROUND BAR  
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)  
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)  
OR ASTM B211 OR ASTM B221  
REF DART SPEC M6061T6R
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.01 lbs

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D3520	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	(A119 BASKET) SPACER	NTS
DATE	10.11.11	COPYRIGHT © 2006 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. WHEN SUPPLIED ON THE EXPRESS OR IMPLIED CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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